Work Order ID 74548 Tuesday, October 04, 2011 9:57:										Page 1
	tart Qty: 6.00 eq'd Qty: 6.00		Accept	Cust Item I			s	Setup Star	1 100111010	1818 181 188 1888 1881 1881
	MLJ	Date: 1110			nte:		P	Run Sta		
	peration escription		Set Up/ Run Hours	Tool ID	Tool#		ccept Oty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr Revisio D3197 Rev B	on Nbr								· · · · · · · · · · · · · · · · · · ·	
Bandsaw Jeaspa Bandsaw	AND SAW Memo Cut blanks	: 29.125" long	0.00 JL	11-10-14		(Ø		
HAAS 1 HAAS CNC vertical machine #1	AAS CNC VERTICA Memo 1-Face end and Dwg D	L MACHINING #1 s to lenght per dwg D3197 D3197 □3-Deburr	0.00 0.00 □2-Machine D3197-1 as	per Folio FA340 ــــــــــــــــــــــــــــــــــــ	11-10-17		6	φ	-	
120 Q0	C2- Inspect parts off	machine FAI/FAIB	0.00	SL 11-10-17			6	_		· · · · · · · · · · · · · · · · · · ·

Quality Control

	•								•
W/O:	<u> </u>		WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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1.50									
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	\:	Date: _	
		esolution:							
NCR:		V	VORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC		on B	Verific	ation	Approval	Approval	
DAIL	SIEF	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector
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Work Order ID 74548

Required Date: 10/14/2011

Tuesday, October 04, 2011 9:57:16 AM



Page 2

Item ID:

D3197-041

Accept



Setup Start



Revision ID:

Item Name:

Bar Assembly

Start Date:

9/30/2011

Start Oty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

× Run

Start

Stop

Stop



Sequence ID/

QC:

Date: _____

SPC (Y/N):

Tool # Plan

Code

Accept Otv

Reject Oty

Reject Insp. Number Stamp

Work Center ID 130

Lathe Conv

Conventional Lathe

Operation Description

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

Set Up/ Run Hours 0.00

JL 1410-14

140

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

B.0 11/10/17

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

6x DM-Lnlon

Hand Finishing

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES							
DATE	STEP		OCEDURE CHAN	IGE	1	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
												
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:							
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NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)						
		Description of NC	escription of NC Corrective Action				Vorifie	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign & Date		Section C		Chief Eng	QC Inspector		
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Work Order ID 74548

Tuesday, October 04, 2011 9:57:16 AM



Page 3

Item ID:

D3197-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bar Assembly

Start Date:

Required Date: 10/14/2011

9/30/2011

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start Stop

Sequence ID/ Work Center ID

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Set Up/ Run Hours Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Insp. Reject Number Stamp

160

Powdercoat

Powder Coating

Memo

—□FINISH TIME:

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

BP 11-10-19

180

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Assemble D3197-041 as per Dwg D3197

W/O:			W	WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Cat	egory:	NO	CR: Yes	No DQ	\ :	Date: _			
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NCR:		1	WORK ORI	DER NON-CON	FORMANC	E (NCR)					
DATE	STEP	Description of NC	Description of NC Corrective Actio				Verific	ation	Approval	Approval		
DATE	SIEF	Section A	Initial Chief Eng			Sign & Date			Chief Eng	QC Inspector		
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Work Order ID 74548

Tuesday, October 04, 2011 9:57:16 AM



Page 4

Item ID:

D3197-041

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bar Assembly

Required Date: 10/14/2011

9/30/2011

Start Oty: 6.00

Req'd Qty: 6.00



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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Set Up/

Date:_

Stop



Sequence ID/ Work Center ID

190

QC

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location.

Run Hours

0.00

Tool ID Tool#

Plan Qty Code

Accept Reject Qty

Reject Number

Insp. Stamp

200

Packaging Packaging

Memo

Memo

0.00

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROC	EDURE CH	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Cat	egory:	_ NCR:	Yes N	o DQ	A:	Date:	
	R	esolution:	_ Dispositi	on:	_ QA: N	/C Clos	sed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section B			Verific	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng				ion C	Chief Eng	QC Inspector
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Picklist Print

Tuesday, October 04, 2011 9:57:21 AM

Work Order ID: 74548

Parent Item:

D3197-041

Parent Item Name: Bar Assembly



Start Date: 9/30/2011

Required Date: 10/14/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev: A New Issue 05-11-08 JLM

IPP Rev-B As per Rev B 06-03-10 ILM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	86.0000	2	12	1/11/0	<i>j</i>	
				Location		Loc	<u>Oty</u>	Loc Code					
				ST292	100151	•	86 86			12	-		
AN960JD10 	NAS1149D0363J		601	362		180	Each	0.0000	6	36	, 	101	,
02690-5 Lanyard Assembly		Manufactured	No			180	Each	11.0000	2 /	12/5/1	[][]0		·····
				Location ST020	73321	Loc	<u>Otv</u> 11 ≠ 7 / O	Loc Code		10	- 'B	733	21(
D3242-1		Manufactured	No			180	Each	12.0000		12	54/1	101	
				Location	<u>l</u>	Loc	<u>Qty</u>	Loc Code		//	•		
		-		ST044			12		_	1)			

12 73502

W/O:			V	ORK ORDER CHANG	ES						
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector			
			<u> </u>				Prod Mgr				

Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:						
	Re	esolution:	Disposit	ion:	QA: N/C Clo	sed:	Date: _				
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCR)						
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval			
DATE	SIEF	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector			
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Tuesday, October 04, 2011 9:57:21 AM

Work Order ID: 74548

Parent Item:

D3197-041

Parent Item Name: Bar Assembly



GA

No .

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

PIP PIN

Manufactured No 180

Each

12.0000

2

Location Loc Qty 73503 ST062 70271 180 48.7150 2.42 18.15

· M7075T73R1.000 Purchased

7075-T73 Rd Bar 1.00

Location	Loc Qty	Loc Code
MAT012	48.715	
115165	2.7	
116405	4.54	
116604	2.25	
116835	2.32	
116962	0.905	
118305	12	
110040	24	

Da	rt /	Aeı	ros	pa	ce	Ltd
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W/O:			W	ORK ORDER CHANG	SES					
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		·· ,								
Part No	•	PAR #:	Fault Cate	Fault Category: NCR: Yes No DC				DQA: Date:		
	R	esolution:	Disposition	on:	QA: N/	C Clos	sed:		Date: _	
NCR:			WORK ORE	ER NON-CONFORM	ANCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	tion B	Veri		cation on C	Approval Chief Eng	Approval QC Inspector
		Gection A	Chief Eng	Chief Eng		Date	Jeon		Omor Eng	QO MOPOCION
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Picklist Print

Tuesday, October 04, 2011 9:57:22 AM

Work Order ID: 74548

Parent Item:

D3197-041

Parent Item Name: Bar Assembly



119075

Start Date: 9/30/2011

Required Date: 10/14/2011

Page 3

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Nut

Purchased

No

180

Each

3000

11,174.00

Location	Loc Oty	Loc Code
ST300	2174	
117441	16	
117601	68	
117885	97	
118451	993	
118927	1000	
ST516	6000	
119017	6000	
ST518	3000	

W/O:	<u> </u>	and the second s	M	VORK ORDER CHANGE	S			
DATE	STEP	PROCEDURE CHANGE				Date Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No	: <u> </u>	PAR #:	Fault Ca	itegory:	NCR: Yes	No DQA :	Date: _	
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DART AEROSPACE LTD	Work Order:	
Description: Bar	Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1

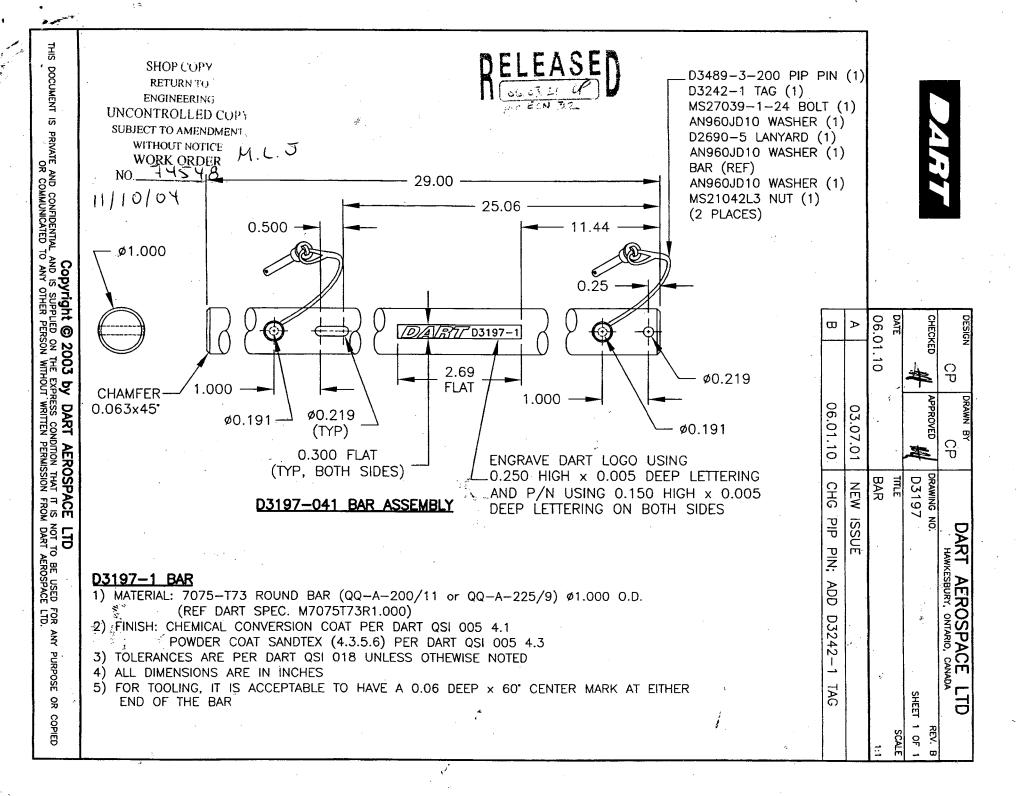
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00			m-upe	
25.06	+/-0.030	25.06			"-	
11.44	+/-0.030	11.445			Vernew-02	
0.500	+/-0.010	.499			vern 1-3	
0.250	+/-0.030	-258			,	
Ø0.219	+0.005/-0.000	-220			-	
Ø0.191	+0.005/-0.000	.192			,	
1.000	+/-0.005	1.000	/			
2.69	+/-0.030	2689	/			<u> </u>
1.000	+/-0.010	1.000				
0.300	+/-0.010	.300				
0.063 x 45°	+/-0.010	-06×450			·	
Ø1.000	+/-0.010	-998				
						·
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Measured by:	SL	Audited by:	H.A	Prototype Approval:	N/A
Date:	11-10-17	Date:	1/10/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
			KJ/JLM	
В	07.03.09	Dwg revision update	KJ/JLM O	B



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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE					Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		PAR #:	Fault Car	tegory:		NCR	: Yes N	lo DQ	\:	_ Date: _		
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		V	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC		Corrective Action Section					Verification		Approval	
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